

WHAT IS CLAIMED IS:

1. An in-mold foam molding, wherein a recess is formed to the outside of a boundary, said boundary lying between molded sections molded using bead starting materials of different properties, with flash being formed at the bottom of said recess so as to not project out from visible surfaces of the molded article.
2. An in-mold foam molding having a plurality of molded sections molded using bead starting materials of different properties, a plurality of through-holes or wells extending in the mold parting direction being formed at predetermined intervals along the boundary of each of molded section.
3. The in-mold foam molding according to claim 2, wherein a recess is formed along a boundary on the outside face of a portion of the boundary devoid of through-holes or wells, with flash being formed at the bottom of said recess so as to not project out from visible surfaces of the molded article.
4. The in-mold foam molding according to claim 3,

wherein the boundary of molded portions having said through-holes or wells formed therein are of rectangular wave, triangular wave, or sine wave configuration.

5. The in-mold foam molding according to claim 1, wherein said in-mold foam molding is a car bumper core, portions of the core susceptible to localized impact stress acting on the core during automobile frontal collisions of various kinds being composed of low-expansion portions comprising a bead starting material having a low degree of expansion, with other portions being composed of high-expansion portions comprising a bead starting material having a high degree of expansion than the low-expansion portions.

6. The in-mold foam molding according to claim 2, wherein said in-mold foam molding is a car bumper core, portions of the core susceptible to localized impact stress acting on the core during automobile frontal collisions of various kinds being composed of low-expansion portions comprising a bead starting material having a low degree of expansion, with other portions being composed of high-expansion portions comprising a bead starting material having a high degree of expansion than the low-expansion

portions.

7. The in-mold foam molding according to claim 3, wherein said in-mold foam molding is a car bumper core, portions of the core susceptible to localized impact stress acting on the core during automobile frontal collisions of various kinds being composed of low-expansion portions comprising a bead starting material having a low degree of expansion, with other portions being composed of high-expansion portions comprising a bead starting material having a high degree of expansion than the low-expansion portions.

8. The in-mold foam molding according to claim 4, wherein said in-mold foam molding is a car bumper core, portions of the core susceptible to localized impact stress acting on the core during automobile frontal collisions of various kinds being composed of low-expansion portions comprising a bead starting material having a low degree of expansion, with other portions being composed of high-expansion portions comprising a bead starting material having a high degree of expansion than the low-expansion portions.